



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2322

Job Sheet 178549



Part No: D2322

Job Qty: 12 ea

Part Name: Step Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/1/18

Job Tracking No:

Due Date: 6/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP Rev:A New Issue 05-11-07 JLM IPP Rev;B Now on Waterjet 06-07-03 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		6/20/18	0.00	0.00	Start Up Waterjet		SC 18/06/11
100	Waterjet	12 pcs		6/20/18	0.00	0.66	Waterjet1		SC 18/06/11
120	QC	12 pcs		6/20/18	0.00	0.00	QC8		23
130	Brake NC	12 pcs		6/20/18	0.05	0.38	Brake NC 1		38
140	QC	12 pcs		6/20/18	0.00	0.00	QC5		38
150	HandFinish	12 pcs		6/20/18	0.00	0.48	HandFinish1		SA 18/06/11 - 21
160	QC	12 pcs		6/20/18	0.00	0.00	QC7		38
170	Packaging	12 pcs		6/20/18	0.00	0.00	Packaging3		SP 18/06/11
180	QC21-SA	12 Ea		6/20/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg D2322
Descriptions: 130 - Form as per Dwg D2322
170 - LOCATION : GA

DAG 21 JUN 27 2018
9-50

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	2.4360 sf (.203 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.040	2	171	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Spacer	0.250Inches ± 0.005	0.255 0.245	0.249	
2	Step Spacer	4.178Inches ± 0.005	4.183 4.173	4.179	
3	Step Spacer	4.428Inches ± 0.010	4.438 4.418	4.43	
4	Step Spacer	0.250Inches ± 0.005	0.255 0.245	0.251	
5	Step Spacer	6.520Inches ± 0.010	6.530 6.510	6.516	

Work Order update only

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev I

6	Step Spacer	0.128Inches + 0.005 - 0.000	0.133 0.128	0,129	Diameter
7	Step Spacer	0.125Inches ± 0.010	0.135 0.115	0,124	Radius

Plex 6/1/18 1:45 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																			
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